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(54) **HOT MELT ADHESIVE BASED ON BLENDS OF EPR AND/OR EPDM AND SEMICRYSTALLINE OLEFINIC POLYMERS**

**SCHMELZHAFTKLEBER AUF BASIS VON MISCHUNGEN VON EPDM- UND/ODER  
EPR-POLYMEREN UND SEMIKRISTALLINE OLEFINISCHE POLYMEREN**

**ADHESIF THERMOFUSIBLE A BASE DE MELANGES D'EPR ET/OU D'EPDM ET DE POLYMERES  
OLEFINIQUES SEMI-CRISTALLINS**

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(56) References cited:  
**US-A- 5 412 035 US-A- 5 504 136**

• **PATENT ABSTRACTS OF JAPAN vol. 1996, no.  
05, 31 May 1996 (1996-05-31) & JP 08 003527 A  
(DU PONT MITSUI POLYCHEM CO LTD), 9  
January 1996 (1996-01-09)**

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## Description

## FIELD OF INVENTION

5 [0001] This invention relates to novel hot melt adhesive compositions based on ethylene propylene rubber (EPR) and semicrystalline olefinic polymer mixtures. More particularly, this invention relates to adhesive compositions which find utility in manufacturing nonwoven disposable articles such as diapers and feminine care products. The adhesive compositions of the present invention are particularly useful in applications where non-contact patterned coating techniques, such as spiral spray, melt blown and multibeads, are involved.

## BACKGROUND OF THE INVENTION

10 [0002] Hot melt adhesives typically exist as solid masses at ambient temperature and can be converted to a flowable liquid by the application of heat. These adhesives are particularly useful in manufacturing of a variety of disposable goods where bonding of various substrates is often necessary. Specific applications include disposable diapers, hospital pads, sanitary napkins, pantyshields, surgical drapes and adult incontinent briefs, collectively known as disposable nonwoven products. Other diversified applications have involved paper products, packaging materials, tapes and labels. In these applications, the hot melt adhesive is heated to its molten state and then applied to a substrate. A second substrate is then immediately brought into contact with and compressed against the first. The adhesive solidifies on cooling to form a strong bond. The major advantage of hot melt adhesive is the lack of a liquid carrier, as would be the case of water or solvent based adhesives, thereby eliminating costly processes associated with liquid carrier removal.

20 [0003] For many applications, hot melt adhesives are often extruded directly onto a substrate in the form of a thin film through a slot die by using piston or gear pump equipment. In these cases, the substrate is brought into intimate contact with a hot die under pressure. The temperature of the die must be maintained well above the melting point of the adhesive, typically in the range of 150 to 200°C. For some applications, particularly for manufacturing nonwoven articles, bonding of delicate and heat sensitive substrates, such as thin gauge polyethylene film, is often involved. Direct contact between the substrate and the die, in these cases, must be avoided to prevent the substrate from burning or distorting. Several application methods have been developed through which a hot melt adhesive can be spray coated with the aid of compressed air onto the substrate from a distance. These techniques include spiral spray, and various forms of melt-blown methods. Direct contact between the coating head and the substrate is thus eliminated. All the coating techniques mentioned above are well known to those skilled in the art and commercial equipment is readily available.

30 [0004] The indirect coating techniques, however, pose stringent requirements on hot melt adhesives. The viscosity of the adhesive must be sufficiently low, usually in the range of 2,000 to 30,000 cP, preferably in the range of 2,000 to 15,000 cP, at the application temperature. Many other physical factors, especially the rheological properties of the adhesive, come into play in determining the sprayability of a hot melt adhesive. The majority of commercial hot melt products do not lend themselves to spray applications. There are no widely accepted theoretical models or guidelines to predict sprayability and it must be determined empirically with application equipment.

40 [0005] Adhesives based on EPR are known in the art. Adhesives based on EPR alone lack sufficient cohesion and thus prior art EPR adhesives often rely on chemical curing to improve cohesive strength and bonding characteristics. Due to the presence of curing agents, these adhesives are not suitable for applications with conventional hot melt coating equipment. The curing agents may cause premature curing or crosslinking of the adhesive inside the coater and render the machine useless. Furthermore, most prior art adhesives are either solvent based or in the form of pre-formed tapes. They can not be considered as hot melt adhesives.

45 [0006] Tynan et al U.S. Patent 5,798,175 discloses pressure sensitive adhesive (PSA) compositions based on a natural rubber or synthetic rubber and an amorphous polyolefin blend comprising EPR, hydrogenated polyisoprene and atactic polypropylene (APP). The adhesives are prepared by compounding the above-mentioned polymers, a compatible tackifier and an organic solvent. The adhesives are thus solvent based and not hot melts.

50 [0007] Davis et al U.S. Patent 5,612,144 and European Patent Application EPO 714963A2 disclose an adhesive tape composition comprising a polymer blend of at least one EPDM rubber, or preferably three different grades of EPDM rubbers in equal amounts, and another polymer selected from polyisoprene, polybutadiene, EPR, and mixtures thereof. The tape composition further includes at least one tackifier and a sulfur curing package. The composition has extremely high viscosity and contains curing agents, and therefore, can not be considered as hot melt adhesive in a conventional sense.

55 [0008] Davis et al European Patent Application 0672737A1 discloses an adhesive tape composition comprising at least one crosslinkable EPDM, one or more compatible tackifiers, a filler, a softener and a curing system for the rubber polymer. The inclusion of curing agents and unusually high viscosity make the composition unsuitable for hot melt applications.

[0009] Planthottam et al U.S. Patent 5,618,883 discloses a hot melt pressure sensitive adhesive composition comprising a tackified EPR rubber modified with a copolymer of styrene-ethylene-butylene-styrene block copolymer and/or styrene-ethylene-propylene-styrene block copolymer.

[0010] McEbrath Jr. et al U.S. Patent 5,010,119 discloses a curable adhesive composition comprising an elastomer grafted with a  $C_3 - C_{10}$  unsaturated mono- or poly-carboxylic acid or anhydride, a tackifier and a crosslinking agent.

[0011] Tape compositions have also been disclosed in U.S. Patents 4,379,114, 4,404,056 and 5,242,727. These compositions usually contain an EPDM, or a blend of EPDM with other elastomers including butyl rubber, polyisoprene, halogenated butyl rubber and styrenebutadiene rubber, a tackifier, a curing system and other optional ingredients such as plasticizers and fillers and the like.

[0012] It is apparent that all the above prior art adhesive compositions are based on EPDM or EPR rubber, either alone or in combination with other type of rubbers. It is well known to those skilled in the art that all the rubbers noted hereinabove are amorphous polymers. The definition of amorphous polymers and its contrast to crystalline polymers can be found in most polymer chemistry textbooks such as *Polymers, Chemistry and Physics of Modern Materials* by J.M.G. Cowie, 2<sup>nd</sup> Edition, Blackie Academic and Professionals.

[0013] These prior art compositions rely on curing or chemical crosslinking to acquire good cohesive strength and good adhesion characteristics. When uncrosslinked, adhesives based on EPR and EPDM show poor cohesive strength and poor bond strength. The presence of curing agents, and solvent in some prior art compositions, practically made them useless for hot melt applications since the curing agents may cause gelling or crosslinking of the adhesive before they can be applied to a substrate. Such gelling or crosslinking can take place in any component of the coating equipment that involves storage and transport of the molten adhesive mass to the coating head, thereby plugging the equipment and causing severe damage to the coater itself. Further, viscosities of the prior art adhesives are usually very high and beyond the capability of conventional hot melt coating equipment.

#### SUMMARY OF THE INVENTION

[0014] The present invention is directed to a hot melt adhesive composition based on tackified EPR and/or EPDM rubber and at least one semicrystalline olefinic polymer. The compositions of the present invention have overcome the shortcomings of the prior art EPR and EPDM adhesives and provide excellent heat stability, improved cohesive strength, low viscosity, and good adhesion to a variety of substrates and good processibility with conventional coating equipment. In particular, the present invention provides an adhesive composition which is suitable for a variety of spray coating application techniques.

[0015] The hot melt adhesive composition of the present invention comprises a mixture of the following ingredients:

- a. an elastomeric rubber or a blend of elastomeric rubbers selected from EPR and EPDM rubbers, preferably in the amount of about 5% to 65% by weight,
- b. at least one semicrystalline olefinic polymer or a blend of semicrystalline olefinic polymers, preferably in the amount of 5% to 40% by weight,
- c. a compatible tackifier, preferably in the amount of 15% to 75% by weight,
- d. a plasticizer, preferably in the amount of 0% to 30% by weight,
- e. about 0% to 30% by weight of a wax,
- f. about 0% to 2% by weight of a stabilizer or antioxidant and
- g. optionally up to 50% by weight of a filler,

the components of the composition adding up to 100% by weight. The adhesive composition may contain other ingredients which can modify the adhesive properties of the above basic adhesive composition.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0016]

Fig. 1 is a schematic illustration of a desired perfect spiral spray pattern for the adhesive composition of the present invention; and

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10min (ASTM D-1238) and a melting point of about 150°C (DSC), manufactured using Catalloy process by Montell North America Inc.

[0046] Adflex KS084P is a blend of EPR rubber and semicrystalline propylene polymer with melt flow rate of 30 g/10min (ASTM D-1238) and a melting point of about 155°C (DSC), manufactured with mechanical blending by Montell North America Inc.

[0047] Vistalon 703, available from Exxon Chemical Company, is an EPR rubber containing 72% by weight of ethylene comonomer and having a Mooney number of 20 (ASTM D-1646, ML 1+4 at 125°C).

[0048] Vistalon 7800, available from Exxon Chemical Company, is an EPR rubber containing 68% by weight of ethylene comonomer and having a Mooney number of 20 (ASTM D-1646, ML 1+4 at 125°C).

[0049] MDV 91-9, available from Exxon Chemical Company, is an EPR rubber containing 60% by weight of ethylene comonomer and having a Mooney number of 18 (ASTM D-1646, ML 1+4 at 125°C).

[0050] Keltan 1446A, manufactured by DMS Company Inc., is an EPDM containing 58% by weight of ethylene, 7% by weight of ethylidene-norbornene (ENB) and having a Mooney number of 10 (ASTM D-1646, ML 1 +4 at 125°C).

[0051] Rexflex W218 is a semicrystalline ethylene-propylene copolymer consisting of 10% by weight of ethylene. It was obtained from Huntsman Corporation.

[0052] Exact 4038, a semicrystalline ethylene-butene-1 copolymer made by using a metallocene catalyst, having a melt index (MI) of 125 dg/min, a density of 0.885 g/cc and a butene-1 content of 19% by weight, is acquired from Exxon Chemical Company.

[0053] Escorene MV02514, a semicrystalline ethylene-vinyl acetate copolymer having a MI of 2500 dg/min and 14% by weight of vinyl acetate, is obtained from Exxon.

[0054] Evatane 18-500, a semicrystalline ethylene-vinyl acetate copolymer having a MI of 500 g/10min and 18% by weight of vinyl acetate, is purchased from Elf Atochem North America Inc.

[0055] Lotryl 10BA175, a semicrystalline ethylene-butyl acrylate copolymer having a MI of 175g/10 min and 10% by weight of butyl acrylate, is obtained from Elf Atochem North America Inc.

[0056] Duraflex PB 8910PC is a semicrystalline copolymer of ethylene and butene-1 containing 5.5% by weight of ethylene. It is available from Montell North America Inc.

[0057] Escorez 5400, purchased from Exxon, is a very light color, hydrogenated cycloaliphatic hydrocarbon tackifying resin having a R&B softening point of 103°C and weight average molecular weight (Mw) of about 440.

[0058] Escorez 5600, also purchased from Exxon, is a very light color, aromatic modified hydrogenated cycloaliphatic hydrocarbon tackifying resin having a R&B softening point of 100°C and weight average molecular weight (Mw) of about 520.

[0059] Escorez 1310LC, another tackifying resin purchased from Exxon, is a light color, aliphatic hydrocarbon resin having a R&B softening point of 93°C and weight average molecular weight (Mw) of about 1350.

[0060] Regalite S1100, purchased from Hercules Corporation, is a fully hydrogenated C9 resin having a R&B softening point of about 100°C.

[0061] Piccotac 95, available from Hercules, is an aliphatic hydrocarbon tackifying resin having a R&B softening point of about 96°C.

[0062] Sylvares 1100, available from Arizona chemical Company, is a polyterpene tackifying resin having a R&B softening point of 100°C.

[0063] Sylvares ZT5100, also available from Arizona chemical Company, is a styrenated polyterpene tackifying resin having a R&B softening point of 94°C.

[0064] Eastotac H100W and H115R are hydrogenated C5 aliphatic hydrocarbon resins having R&B softening points of 100 and 115°C, respectively. They are purchased from Eastman Chemical Company.

[0065] Epolene N-15, available from Eastman Chemical Company, is a propylene derived synthetic wax having a R&B softening point of 163°C and a Brookfield viscosity of 600 cP at 190°C.

[0066] Marcus 300, purchased from Marcus Oil & Chemicals, Inc., is a synthetic polyethylene wax having a melting point of 240°F.

[0067] Pennznep 500, purchased from Pennzoil Products Co., is a mineral oil plasticizer.

[0068] Irganox 1010 is a hindered phenolic type antioxidant from Ciba Gergy.

### EXAMPLES 1 - 7

[0069] Hot melt adhesives of Table I were prepared with the ingredients and mixing procedures described hereinabove. A total of 2000 grams were made each and the mixing was carried out at 375°F under carbon dioxide atmosphere in a laboratory propeller type mixer which consists of a propeller powered by a motor, a heating mantle, a temperature control unit and a container of about 1 gallon in size. The appropriate amounts of each component calculated according the ratios shown in the table, except the polymers, were added to the container and the temperature of the container was then raised to melt the content. After the ingredients in the container were completely melted, the motor was turned

on to start agitation. Subsequently, the polymer component(s) was (were) introduced. The mixing was continued until the polymer became completely dissolved and a uniform mixture was obtained. A pre-blended polymer alloy, either Adflex KS 357P or Adflex KS084P, was employed for preparing Examples of Table I. These polymer alloys, as described hereinabove, consists of both EPR rubber and semicrystalline olefinic polymer, the two essential polymer components of the present invention. The advantage of using polymer alloys is that the EPR rubber and the semicrystalline polymer reside in one product, thereby simplifying raw material handling. The adhesives of Examples 1 - 7 are useful for a variety of packaging and disposable nonwoven product assembly applications.

[0070] Several tests were carried out on Examples 1 - 7 according to the procedures described above. Specimens for creep resistance and peel strength tests were prepared using Meltex CT225 hot melt coater by laminating three elastic strands (Lycra 740) stretched to 300% between two layers of polypropylene nonwoven fabric of 20 g/m<sup>2</sup> basis weight, and sprayability was also evaluated in the process. Adhesives were spiral sprayed at 18.6 g/m<sup>2</sup> coating weight with a 0.25 seconds open time and 1 bar compression at the nip rolls. While the temperature was kept at 400°F for the heated air used for spraying, the application temperature was adjusted for each adhesive to optimize the spiral pattern. The actual application temperature was shown in Table I for each adhesive.

TABLE I,

EXAMPLES 1 - 7							
Ingredients	Amount (5)						
	1	2	3	4	5	6	7
Adflex KS 357P	20.0	22.0	20.0	15.0	18.0	21.0	-
Adflex KS084P	-	-	-	-	-	-	26.0
Pennznep 500	10.0	15.0	10.0	13.0	10.0	20.0	14.0
Epolene N-15	15.0	10.0	-	17.0	10.0	-	-
Marcus 300	-	-	15.0	-	5.0	-	-
Eastotac H100W	54.0	52.0	54.0	-	-	-	-
Piccotac 95	-	-	-	54.0	-	-	-
Regalite S1100	-	-	-	-	56.0	58.0	-
Eastotac H115R	-	-	-	-	-	-	29.7
Escorez 1310 LC	-	-	-	-	-	-	29.7
Irganox 1010	1.0	1.0	1.0	1.0	1.0	1.0	1.0
Viscosity (cPs), 350 °F	13800	11700	7025	2990	4925	7300	25900
R&B (°F)	295	293	265	299	291	260	308
Application temp. (°F)	365	365	350	350	365	365	350
Sprayability	Exc	Exc	Exc	Exc	Exc	Exc	Exc
Peel strength (g/ in)	866	852	773	826	721	837	798
Creep retention (%)	91	94	95	95	98	88	86

## EXAMPLES 8 - 15

[0071] The components of the adhesives in Examples 8 -15 were mixed according to the ratios shown in Table II to obtain a total of 250 grams for each by using the same procedure as in Examples 1 - 7, except a pint-sized container was used. In these examples, the EPR or EPDM rubber and the semicrystalline polymer were added as separate components. The adhesives in Examples 8 - 15 are useful for a variety of packaging and disposable nonwoven applications. Several tests were carried out according to the methods described above. Specimens for peel test were prepared by laminating two layers of polypropylene nonwoven fabric of 20 g/m<sup>2</sup> basis weight. Adhesives of these examples were spiral sprayed by using Model LH-1 hot melt coater (Acumeter Laboratories) at 14 g/m<sup>2</sup> coating weight with a 0.5 seconds open time. The temperature was maintained at 400°F for the heated air used for spraying and the application temperature, shown in Table II, was adjusted for each adhesive to optimize the spiral pattern. Sprayability was also evaluated during the coating process.



TABLE II.

EXAMPLES 8 - 15								
Ingredients	Amount (%)							
	8	9	10	11	12	13	14	15
Keltan 1446A	20.0	12.0	-	-	-	-	-	-
MVD 91-9	-	-	15.0	10.0	-	-	-	-
Vistalon 7800	-	-	-	-	10.0	-	-	-
Vistalon 703	-	-	-	-	-	10.0	10.0	10.0
Pennznep 500	15.0	15.0	15.0	20.0	5.0	20.0	20.0	20.0
Epolene N-15	10.0	10.0	-	-	-	-	-	-
Marcus 300	-	-	25.0	-	-	-	-	-
Rexflex w218	-	8.0	-	-	-	-	-	-
Exact 4038	-	-	-	30.0	-	-	-	-
Evatane 18-500	-	-	-	-	40.0	-	-	-
Lotryl 10BA175	-	-	-	-	-	10.0	-	-
Escorene MV02514	-	-	-	-	-	-	10.0	-
PB8910PC	-	-	-	-	-	-	-	10.0
Eastotac H100W	54.4	54.4	-	-	-	-	-	-
Piccotac 95	-	-	44.4	44.1	-	-	-	-
Escorez 5600	-	-	-	-	44.4	-	-	-
Sylvares ZT 5100	-	-	-	-	-	59.0	-	-
Sylvares 1100	-	-	-	-	-	-	59.0	59.0
Irganox 1010	0.60	0.60	0.60	0.95	0.60	1.0	1.0	1.0
Viscosity (cPs), 350 °F	13250	10320	11310	30900	4350	11500	6850	4600
R&B (°F)	292	298	244	192	191	192	174	173
Application Temp. (OF)	350	375	350	350	350	350	350	350
Sprayability	Exc	Exc	Exc	Exc	Exc	Exc	Exc	Exc
Peel strength (g/in)	694	766	892	788	830	453	481	480

## Claims

1. A hot melt adhesive composition, comprising a blend of the following components:

- (a) about 5% to about 65% by weight of an elastomeric rubber or a blend of elastomeric rubbers selected from the group consisting of EPR rubbers and EPDM rubbers;
- (b) about 5% to about 40% by weight of a semicrystalline olefinic polymer or a blend of semicrystalline olefinic polymers;
- (c) about 15% to about 75% by weight of a tackifying resin;
- (d) about 0% to about 30% by weight of a plasticizer;
- (e) about 0% to about 30% by weight of a wax; and
- (f) about 0.1% to about 2% by weight of a stabilizer;

wherein the components comprise 100% by weight of the composition.

2. The composition of claim 1 wherein the tackifying resin is selected from the group consisting of aliphatic and cycloaliphatic hydrocarbon resins, aromatic and hydrogenated aromatic hydrocarbon resins, and hydrogenated aliphatic and cycloaliphatic hydrocarbon resins, aromatically modified aliphatic and cycloaliphatic resins and their hydrogenated derivatives, polyterpene and styrenated polyterpene resins.
3. The composition of claim 1 wherein the plasticizer is selected from the group consisting of mineral oil and polybutene.
4. The composition of claim 1 wherein the elastomeric rubber comprises a copolymer of ethylene and propylene containing 15% to 70% by weight propylene.
5. The composition of claim 1 wherein the elastomeric rubber comprises a copolymer of ethylene and propylene containing 20% to 45% by weight propylene.
6. The composition of claim 1 wherein the elastomeric rubber comprises a copolymer of ethylene and propylene modified with a functional monomer selected from the group consisting of a carboxylic acid group, an anhydride group, a hydroxyl group, an ether group, a primary amine group, a secondary amine group, a tertiary amine group and an ester group.
7. The composition of claim 1 wherein the elastomeric rubber comprises a terpolymer of from 15% to 70% by weight propylene, from 20% to 80% by weight ethylene, and from 2% to 15% by weight of a diene.
8. The composition of claim 7 wherein said terpolymer contains 20% to 45% by weight of propylene.
9. The composition of claim 7 wherein said diene is selected from the group consisting of 1,4-hexadiene, norbornadiene, ethylidene-norbomene, dicyclopentadiene, butadiene and isoprene.
10. The composition of claim 7 wherein said terpolymer is further modified with a functional monomer selected from the group consisting of a carboxylic acid group, an anhydride group, a hydroxyl group, an ether group, a primary amine group, a secondary amine group, a tertiary amine group and an ester group.
11. The composition of claim 1 wherein the semicrystalline olefinic polymer is selected from the group consisting of polyethylene, polypropylene, ethylene-propylene copolymers, ethylene-vinyl acetate copolymers, ethylene-acrylic acid copolymers, ethylene-alkyl acrylate or methacrylate copolymers, ethylene-vinyl alcohol copolymers, ethylene-carbon monoxide copolymers, ethylene-alkyl acrylate-(meth)acrylic acid terpolymers, ethylene-alkyl methacrylate-(meth)acrylic acid terpolymers, and mixtures thereof.
12. The composition of claim 1 wherein the wax is selected from the group consisting of low molecular weight polyethylene, petroleum waxes, atactic polypropylene, synthetic waxes, and polyolefin waxes.

#### Patentansprüche

1. Heißschmelzklebstoffzusammensetzung, die ein Gemisch der folgenden Komponenten umfasst:
  - (a) etwa 5 bis etwa 65 Gew.-% elastomeren Kautschuk oder einer Mischung elastomerer Kautschuke ausgewählt aus der Gruppe bestehend aus EPR-Kautschuken und EPDM-Kautschuken,
  - (b) etwa 5 bis etwa 40 Gew.-% semi-kristallines olefinisches Polymer oder einer Mischung semi-kristalliner olefinischer Polymere,
  - (c) etwa 15 bis etwa 75 Gew.-% klebrigmachendes Harz,
  - (d) etwa 0 bis etwa 30 Gew.-% Weichmacher,
  - (e) etwa 0 bis etwa 30 Gew.-% Wachs und
  - (f) etwa 0,1 bis etwa 2 Gew.-% Stabilisator,

wobei die Komponenten 100 Gew.-% der Zusammensetzung ausmachen.

2. Zusammensetzung nach Anspruch 1, bei der das klebrigmachende Harz ausgewählt ist aus der Gruppe bestehend aus aliphatischen und cycloaliphatischen Kohlenwasserstoffharzen, aromatischen und hydrierten aromatischen Kohlenwasserstoffharzen und hydrierten aliphatischen und cycloaliphatischen Kohlenwasserstoffharzen, aromatisch modifizierten aliphatischen und cycloaliphatischen Harzen und deren hydrierten Derivaten, Polyterpen- und styrolisierten Polyterpenharzen.
3. Zusammensetzung nach Anspruch 1, bei der der Weichmacher ausgewählt ist aus der Gruppe bestehend aus Mineralöl und Polybuten.
4. Zusammensetzung nach Anspruch 1, bei der der elastomere Kautschuk ein Copolymer aus Ethylen und Propylen mit 15 bis 70 Gew.-% Propylen umfasst.
5. Zusammensetzung nach Anspruch 1, bei der der elastomere Kautschuk ein Copolymer aus Ethylen und Propylen mit 20 bis 45 Gew.-% Propylen umfasst.
6. Zusammensetzung nach Anspruch 1, bei der der elastomere Kautschuk ein Copolymer aus Ethylen und Propylen umfasst, das mit einem funktionellen Monomer modifiziert ist, das aus der Gruppe bestehend aus einer Carbonsäuregruppe, einer Anhydridgruppe, einer Hydroxylgruppe, einer Ethergruppe, einer primären Aminogruppe, einer sekundären Aminogruppe, einer tertiären Aminogruppe und einer Estergruppe ausgewählt ist.
7. Zusammensetzung nach Anspruch 1, bei der der elastomere Kautschuk ein Terpolymer aus 15 bis 70 Gew.-% Propylen, 20 bis 80 Gew.-% Ethylen und 2 bis 15 Gew.-% Dien umfasst.
8. Zusammensetzung nach Anspruch 7, bei der das Terpolymer 20 bis 45 Gew.-% Propylen enthält.
9. Zusammensetzung nach Anspruch 7, bei der das Dien ausgewählt ist aus der Gruppe bestehend aus 1,4-Hexadien, Norbornadien, Ethylidennorbornen, Dicyclopentadien, Butadien und Isopren.
10. Zusammensetzung nach Anspruch 7, bei der das Terpolymer ferner mit einem funktionellen Monomer modifiziert ist, das aus der Gruppe bestehend aus einer Carbonsäuregruppe, einer Anhydridgruppe, einer Hydroxylgruppe, einer Ethergruppe, einer primären Aminogruppe, einer sekundären Aminogruppe, einer tertiären Aminogruppe und einer Estergruppe ausgewählt ist.
11. Zusammensetzung nach Anspruch 1, bei der das semi-kristalline olefinische Polymer ausgewählt ist aus der Gruppe bestehend aus Polyethylen, Polypropylen, Ethylen/Propylen-Copolymeren, Ethylen/Vinylacetat-Copolymeren, Ethylen/Acrylsäure-Copolymeren, Ethylen/Alkylacrylat- oder -Methacrylat-Copolymeren, Ethylen/Vinylalkohol-Copolymeren, Ethylen/Kohlenmonoxid-Copolymeren, Ethylen/Alkylacrylat/(Meth)acrylsäure-Terpolymeren, Ethylen/Alkylmethacrylat/(Meth)acrylsäure-Terpolymeren und Mischungen derselben.
12. Zusammensetzung nach Anspruch 1, bei der das Wachs ausgewählt ist aus der Gruppe bestehend aus Polyethylen mit niedrigem Molekulargewicht, Erdölwachsen, ataktischem Polypropylen, synthetischen Wachsen und Polyolefinwachsen.

## Revendications

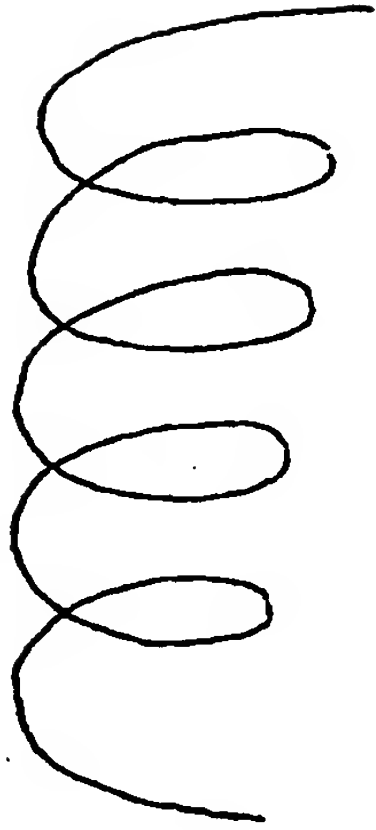
1. Une composition thermofusible et adhésive comprenant un mélange des composés suivants :

- (a) environ 5% à environ 65% en poids d'un caoutchouc élastomérique ou un mélange de caoutchoucs élastomériques choisis parmi le groupe constitué par les caoutchoucs EPR et les caoutchoucs EPDM ;
- (b) environ 5% à environ 40% en poids d'un polymère oléfinique semi-cristallin ou un mélange de polymères oléfiniques semi-cristallins ;
- (c) environ 15% à environ 75% en poids d'une résine collante ;
- (d) environ 0% à environ 30% en poids d'un plastifiant ;
- (e) environ 0% à environ 30% en poids d'une cire ; et
- (f) environ 0,1 % à environ 2% en poids d'un stabilisant ;

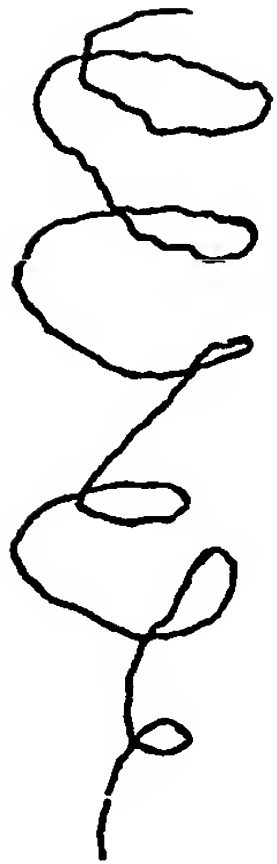


dans laquelle les composants comprennent 100% en poids de la composition.

2. La composition de la revendication 1, dans laquelle la résine collante est choisie parmi le groupe constitué par les résines hydrocarbonées aliphatiques et cycloaliphatiques, les résines hydrocarbonées hydrogénées aromatiques, les résines hydrocarbonées hydrogénées aliphatiques et cycloaliphatiques, les résines aliphatiques et cycloaliphatiques modifiées aromatiques et leurs dérivés hydrogénés, les résines polyterpène et polyterpène styrénique.
3. La composition de la revendication 1 dans laquelle le plastifiant est choisi dans le groupe constitué par l'huile minérale et le polybutène.
4. La composition de la revendication 1, dans laquelle le caoutchouc élastomérique comprend un copolymère d'éthylène et propylène contenant 15% à 70% en poids de propylène.
5. La composition de la revendication 1, dans laquelle le caoutchouc élastomérique comprend un copolymère d'éthylène et de propylène comprenant de 20% à 45% en poids de propylène.
6. La composition de la revendication 1, dans laquelle le caoutchouc élastomérique comprend un copolymère d'éthylène et de propylène modifié par un monomère fonctionnel choisi dans le groupe constitué par un groupe acide carboxylique, un groupe anhydride, un groupe hydroxyle, un groupe éther, un groupe amine primaire, un groupe amine secondaire, un groupe amine tertiaire et un groupe ester.
7. La composition de la revendication 1, dans laquelle le caoutchouc élastomérique comprend un terpolymère contenant entre 15% et 70% en poids de propylène, entre 20% et 80% en poids d'éthylène, et entre 2% et 15% en poids d'une diène.
8. La composition de la revendication 7, dans laquelle ledit terpolymère contient de 20% à 45% en poids de propylène.
9. La composition de la revendication 7, dans laquelle ladite diène est choisie dans le groupe constitué par le 1,4-hexadiène, norbornadiène, éthylidène-norbornène, le dicyclopentadiène, le butadiène et l'isoprène.
10. La composition de la revendication 7, dans laquelle ledit terpolymère est modifié en outre par un monomère fonctionnel choisi dans le groupe constitué par un groupe acide carboxylique, un groupe anhydride, un groupe hydroxyle, un groupe éther, un groupe amine primaire, un groupe amine secondaire, un groupe amine tertiaire et un groupe ester.
11. La composition de la revendication 1, dans laquelle le polymère oléfinique semi-cristallin est choisi dans le groupe constitué par du polyéthylène, du polypropylène, des copolymères d'éthylène-propylène, des copolymères d'éthylène-acétate de vinyle, des copolymères d'éthylène-acide acrylique, des copolymères d'éthylène-acrylate ou méthacrylate d'alkyle, des copolymères d'éthylène-alcool vinylique, des copolymères d'éthylène-monoxycarbonate, des terpolymères d'éthylène-acrylate d'alkyle-acide méthacrylique, des terpolymères d'éthylène-méthacrylate d'alkyle-acide (méth)acrylique, et leurs mélanges.
12. La composition de la revendication 1, dans laquelle la cire est choisie dans le groupe constitué par du polyéthylène à bas poids moléculaire, des cires de pétrole, du polypropylène atactique, des cires synthétiques, et des cires de polyoléfines.



*Fig. 1*



*Fig. 2*